

19-7800.



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3512-041
Job Sheet 203465



Part No: D3512-041

Job Qty: 8 pcs

Part Name: Wearplate



Part Weight: 0 lbs

Status: New

Job Created: 11/20/19

Job Tracking No:

Due Date: 12/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF18-745 DWG D3512 REV:D IPP REV:A 13.07.19 NEW ISSUE DD VERF:JLM IPP REV:B 13.12.11
ECN13-619/ REV.D DWG DD VERF:JLM IPP REV:C 18.03.12 DWG REV:E12 DD VERF:JFS IPP REV:D
18.10.12 BACK TO REV.D DD VERF:RG

Ship Via:

POSITIVE RECALL

EFFECTIVE 19/11/22 AUTH: SMP

RELEASED 10 DATE 19-12-11

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Large Fab - Welded Assy-1	8 pcs	12/2/19	12/2/19	0.00	1.33	Large Fab - 1		EC
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
120	Large Fab - Welded Assy-2-B4B	8 pcs	12/2/19	12/2/19	0.00	1.33	Large Fab - 1 - B4B		EC
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		
							Large Fab - 12 - B4B		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		DAS
							QC 9 - 43		43
							QC 9 - 50		9-89



Container No: S238983



Part: D3512-041

Job No: 203465

Serial No/Batch: S238983

Revision: D

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

TC's

Date: 12/10/19

Plex 11/20/19 8:05 AM Dart.lajeunesse.marie

140 QC 5	8 pcs	12/2/19	0.00 0.00	QC 9 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	DAS
				QC 5 - 49	43
				QC 5 - 51	9-89
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	DAS
142 Spray Paint - 2 - B4B	8 pcs	12/2/19	0.00 0.80	Spray Paint - 1 - B4B	- 41 DEC 10 2019
				Spray Paint - 2 - B4B	9-89
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
144 QC 5	8 pcs	12/2/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS
				QC 5 - 43	81
				QC 5 - 49	9-89
				QC 5 - 51	DEC 11 2019
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Packaging 3-1 - Stock - B4B	8 pcs	12/2/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	26
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	

POSITIVE
RECALL

ok to release
PD 19-12-11

See
Part
Detail

				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - SA	8	12/2/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53

DAS

21

2-00

DEC 11 2019

Part Op 110 - Weld per dwg A/R Hardcoat S.S. Batch: 8259-2059B HARDCOAT BATCH: M139025

Descriptions: 120 - Weld per dwg A/R S.S. rod Batch: M136585

130 - QC9- Inspect visual per QSI004- Fusion Welds

140 - QC5- Inspect part completeness to step on W/O

142 - Assemble as per dwg - Coat wearplate with rockguard as per Dwg and note #10 Batch: S235921

144 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location: _____

160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3512-1	Wearplate	8 pcs (1 ea)	110-Large Fab - Welded Assy-1	<u>2236656</u>
D3512-3	Spacer	8 pcs (1 ea)	110-Large Fab - Welded Assy-1	<u>5236659</u>

Job Allocations

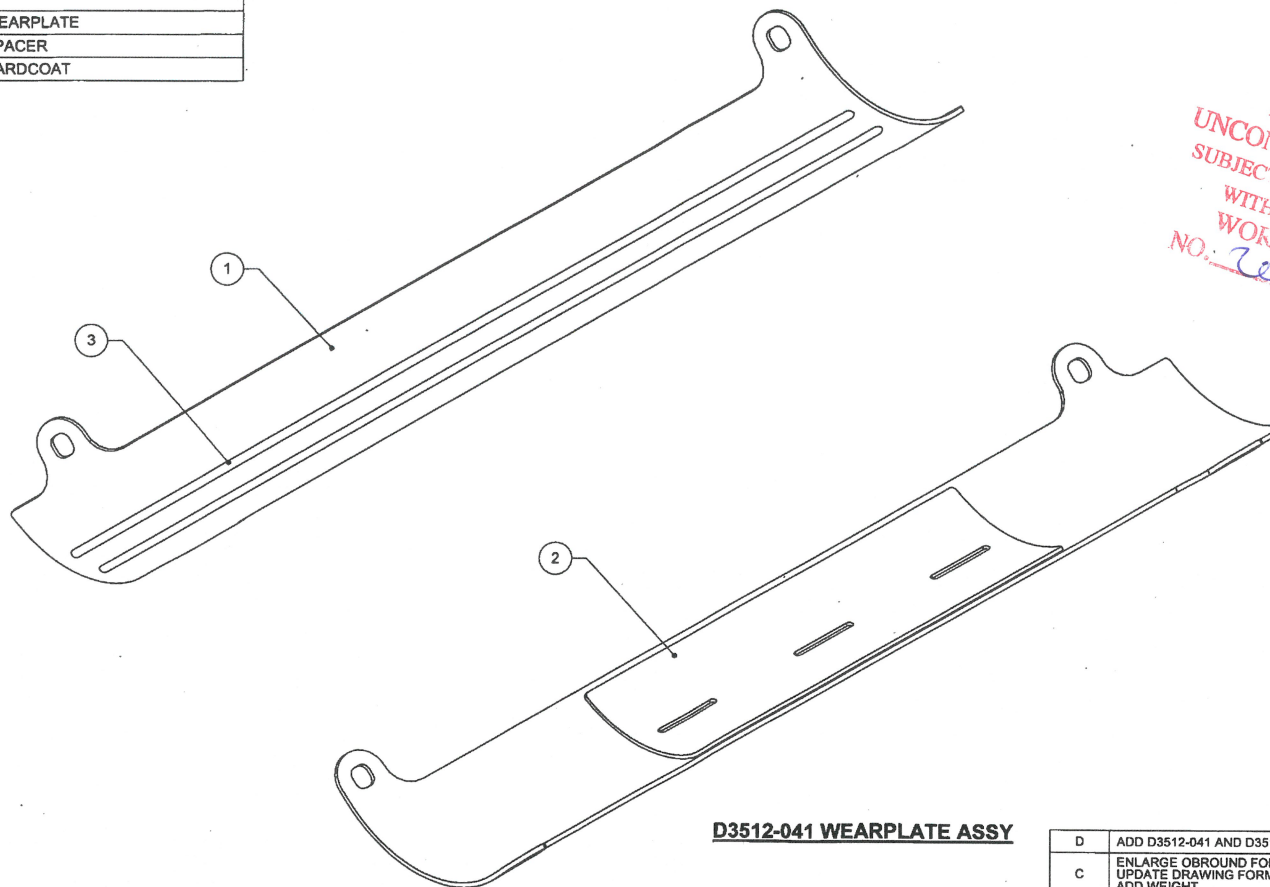
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D3512-1	8	7	0
	D3512-3	8	13	0

Part Specifications

Specifications could not be found.

Plex 11/20/19 8:05 AM Dart.lajeunesse.marie

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3512-041	WEARPLATE ASSY
1	1	D3512-1	WEARPLATE
2	1	D3512-3	SPACER
3	A/R	2059B	HARDCOAT



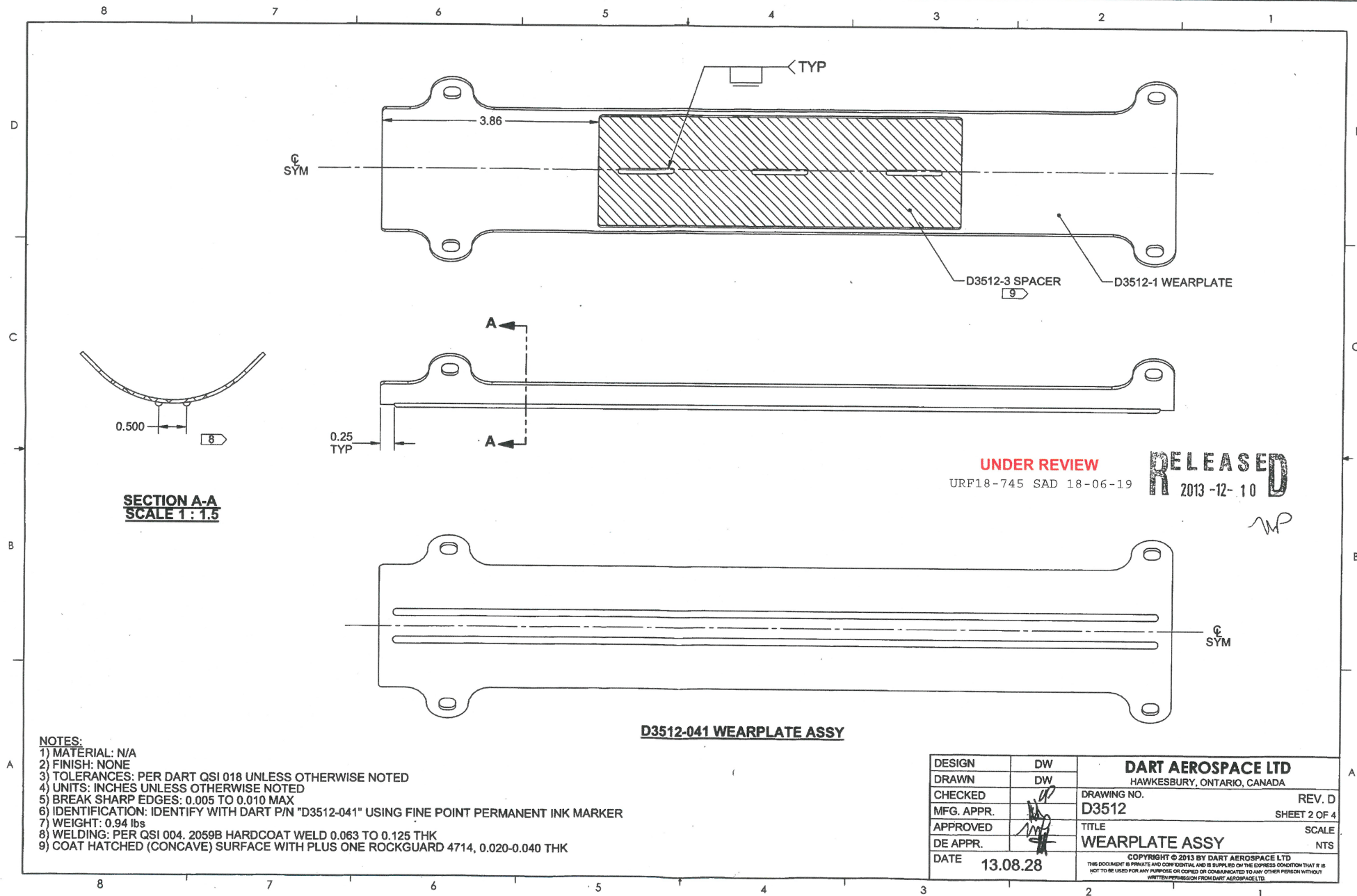
D3512-041 WEARPLATE ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203465 MWS
19-11-20

RELEASED
2013-12-10
wp

UNDER REVIEW
URF18-745 SAD 18-06-19

REV.	DESCRIPTION	BY	DATE
D	ADD D3512-041 AND D3512-3	DW	13.08.28
C	ENLARGE OBOURD FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3512 TITLE WEARPLATE ASSY SCALE NTS REV. D SHEET 1 OF 4 COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DW		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	13.08.28		



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3512-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.94 lbs
- 8) WELDING: PER QSI 004. 2059B HARDCOAT WELD 0.063 TO 0.125 THK
- 9) COAT HATCHED (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714, 0.020-0.040 THK

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.08.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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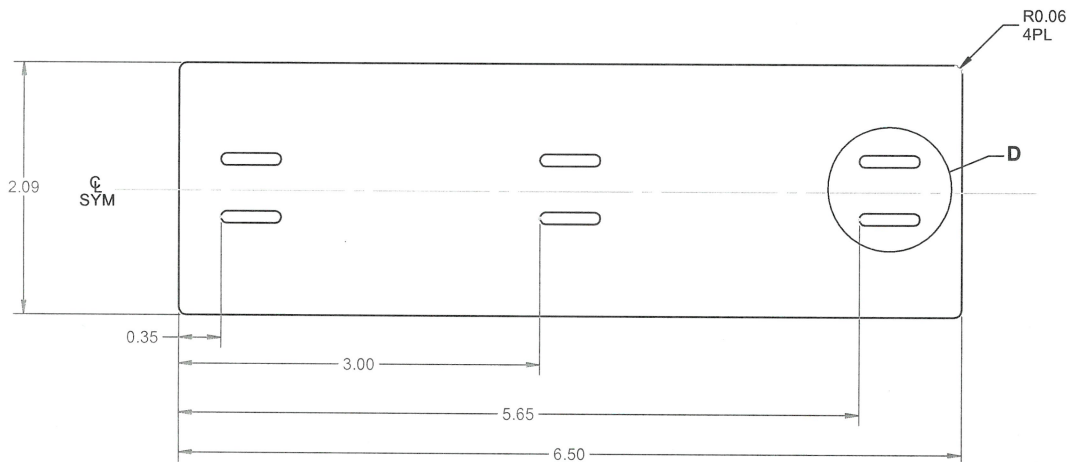
8 7 6 5 4 3 2 1

D

C

B

A



D3512-3F SPACER
(FLAT PATTERN)

REFERENCE ONLY

NOTES:

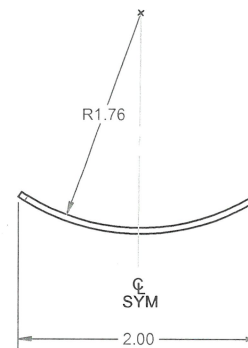
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 18 GAUGE 0.050 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. MS304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

D

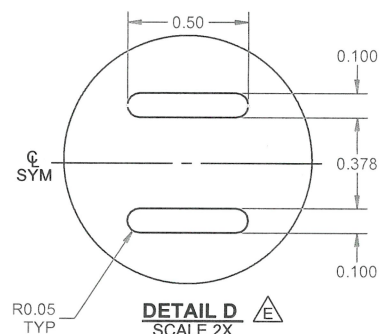
C

B

A



D3512-3 SPACER
(MAKE FROM D3512-3F)

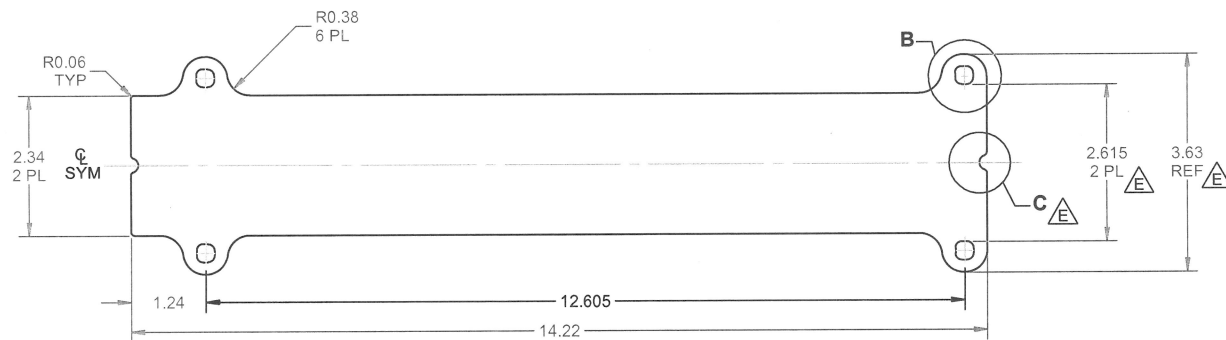


DETAIL D
SCALE 2X
3 PL

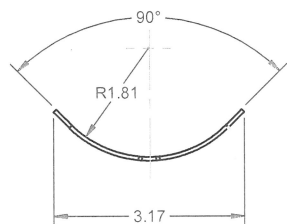
WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE USA, INC.	
DRAWN	SAD	HILLSBORO, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	18.03.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

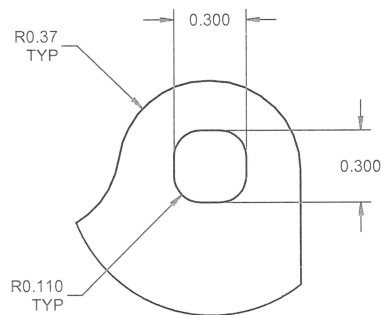
8 7 6 5 4 3 2 1



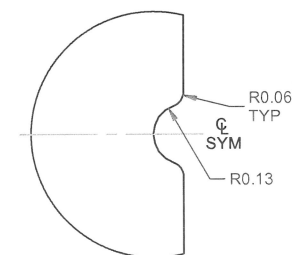
D3512-1F WEARPLATE
(FLAT PATTERN)



D3512-1 WEARPLATE
(MAKE FROM D3512-1F)



DETAIL B
SCALE 4X
4 PL



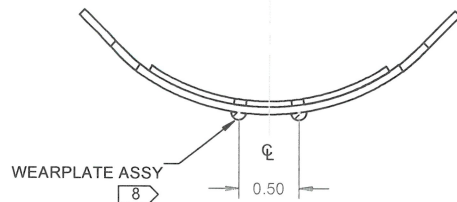
DETAIL C
SCALE 4X
2 PL

NOTES:

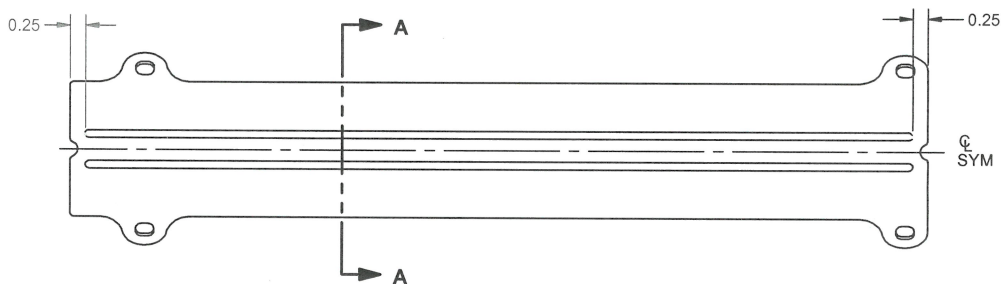
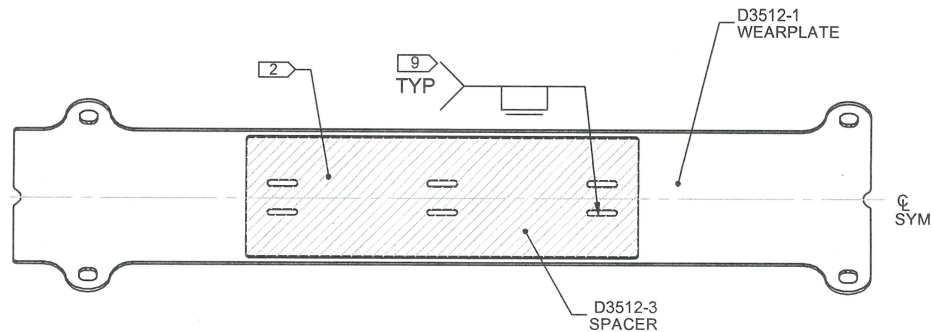
- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. MS304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE USA, INC.	
DRAWN	SAD	HILLSBORO, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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SECTION A-A
SCALE 2X



D3512-041 WEARPLATE ASSY

REFERENCE ONLY

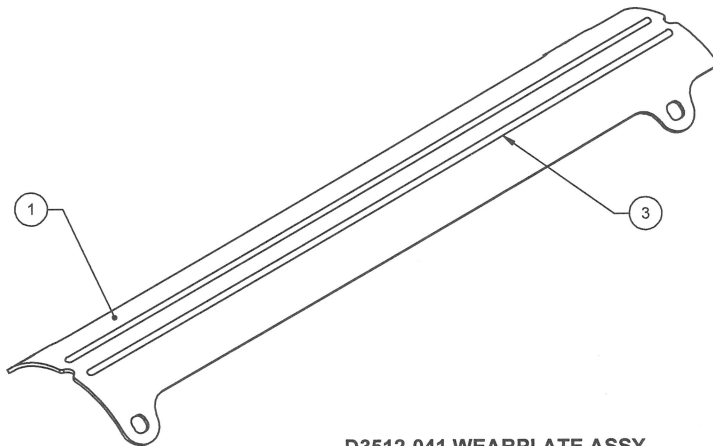
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT HATCHED (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.87 lbs
- 8) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) WELD PER QSI 004

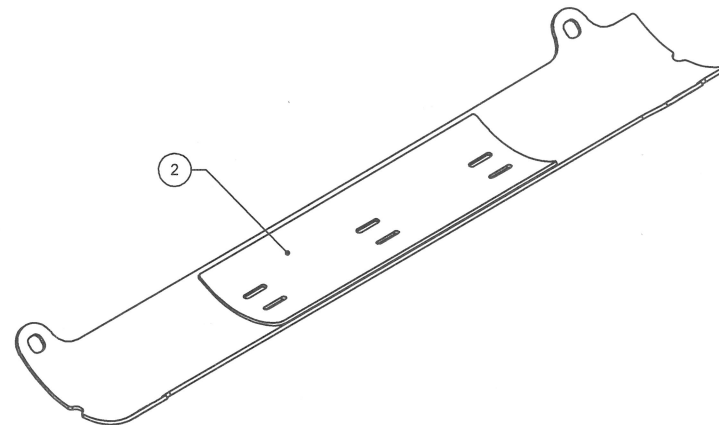
WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE USA, INC.	
DRAWN	SAD	HILLSBORO, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3512-041	WEARPLATE ASSY
1	1	D3512-1	WEARPLATE
2	1	D3512-3	SPACER
3	A/R	8259 \ 2059B	HARD SURFACING



D3512-041 WEARPLATE ASSY



E	ADJUSTED WIDTH OF PART FOR FIT AND FUNCTION, DIM 3.83 WAS 3.84 (ZN D3-3). UPDATE NOTE 8 (ZN A8-2), ADD NOTCHES (ZN D3-3 & D8-3). CHANGE SLOTS TO QTY 6 AND LENGTH TO 0.5 (ZN D4-4). GENERAL UPDATE OF DRAWING TO CURRENT STANDARDS.	SAD	18.03.07
D	ADD D3512-041 AND D3512-3	DW	13.08.28
C	ENLARGE OBOUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE

WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	SAD		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	18.03.07	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

Entered: LR Date: Dec 31/19

Date:

Dec 31/19

NCR No.

19-7800

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only



Job: 203465		DISPOSITION		DEPARTMENT/PROCESS							
Part No. D3512-041		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐	
Date: 19/11/22		Sequence #: 103		QTY Affected:				MRB (QSI042) DAS 51 19/11/22 9-89			
Description Work Order Deviation				Disposition				Completed By 68-6 08 DEC 19 2019 SVC			
minor change to Rev. D, flat Pattern for manufacturability, No change to final bent wearplate				Acceptable to make to Rev. E Ref w/o 193591				Lead hand / Supervisor DAS 9 9-89 19.12-19			
Root Cause				FAULT CATEGORY				QC / QA Coordinator			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ ☒ Drawing Finish ☐ Part Lost/Missing ☐ Misread ☐				QC / QA Coordinator DAS 9 9-89 19.12-19			
Other/Details:											